

Monday, 1/8/2007 10:42:13 AM

Kim Johnston

Process Sheet

Customer

Prsht Rev.

Previous Run

: CU-DAR001 Dart Helicopters Services

Job Number

: 30137

Estimate Number

: 11483

P.O. Number

: 1/8/2007 This Issue

: NC

: 11 First Issue

: 28120

Written By

Checked & Approved By Comment

S.O. No. :

Type

: LARGE FAB ASSY

Re-format DM

Drawing Name

: ASPIRATOR

Part Number

: D2091 : D2091REV. A

Drawing Number Project Number

: N/A

Drawing Revision

Material

: 1/30/2007 **Due Date**

Each

Additional Product

Job Number



Seq. #:

Machine Or Operation:

Description:

1.0 D2000043

Comment: Qty.:



50.0000 Each(s) Total:

Jet

Jet Pick:

D2094

Qty Part Number

Description

1.0000 Each(s)/Unit

D2000-043 Jet

Aspirators

Comment: Qty.:

1.0000 Each(s)/Unit Total:

50.0000 Each(s)

Aspirator Pick:

Qty Part Number D2094

Description Aspirator Body

Batch

3.0

2.0

D2095

Aspirator



Comment: Qty.:

1.0000 Each(s)/Unit Total:

50.0000 Each(s)

Aspirator

Pick:

Qty Part Number Description D2095

Batch

4.0

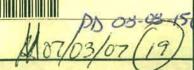
LARGE FAB 1

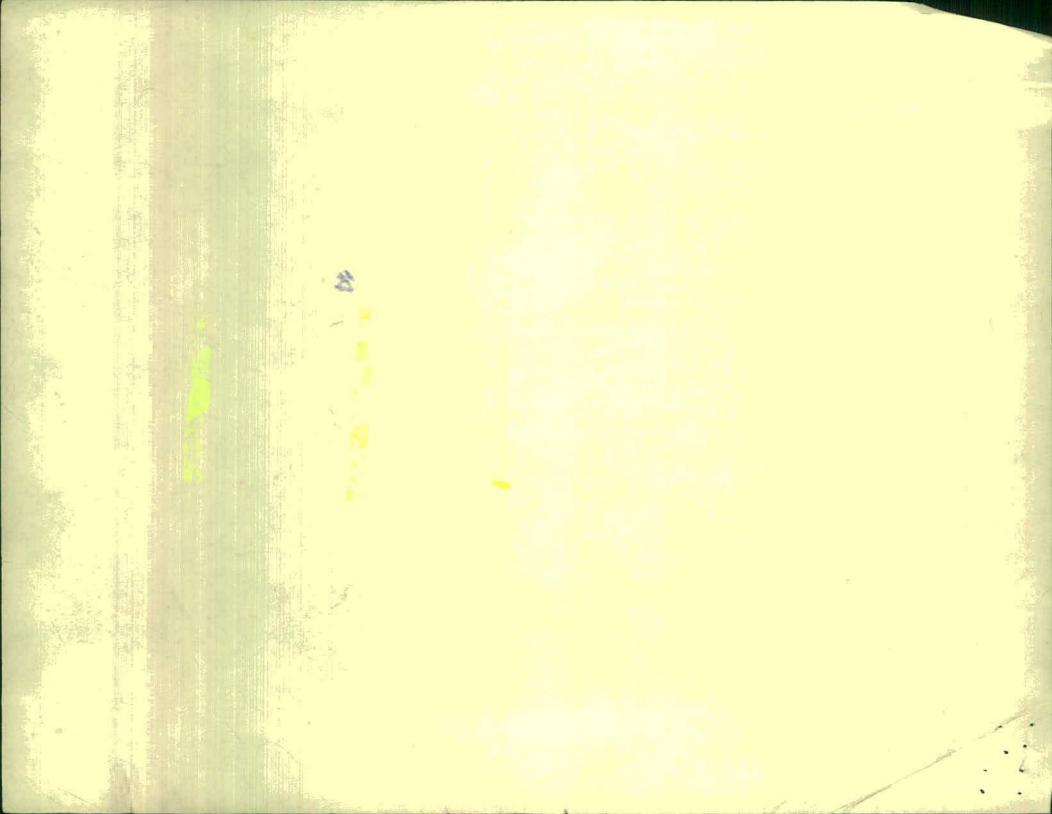
Aspirator Core

LARGE FABRICATION RESOURCE 1

Comment: LARGE FAB RESOURCE 1

Weld D2000-043 Jet to D2094 Aspirator Body as per Dwg D2091 using Jig DT8294

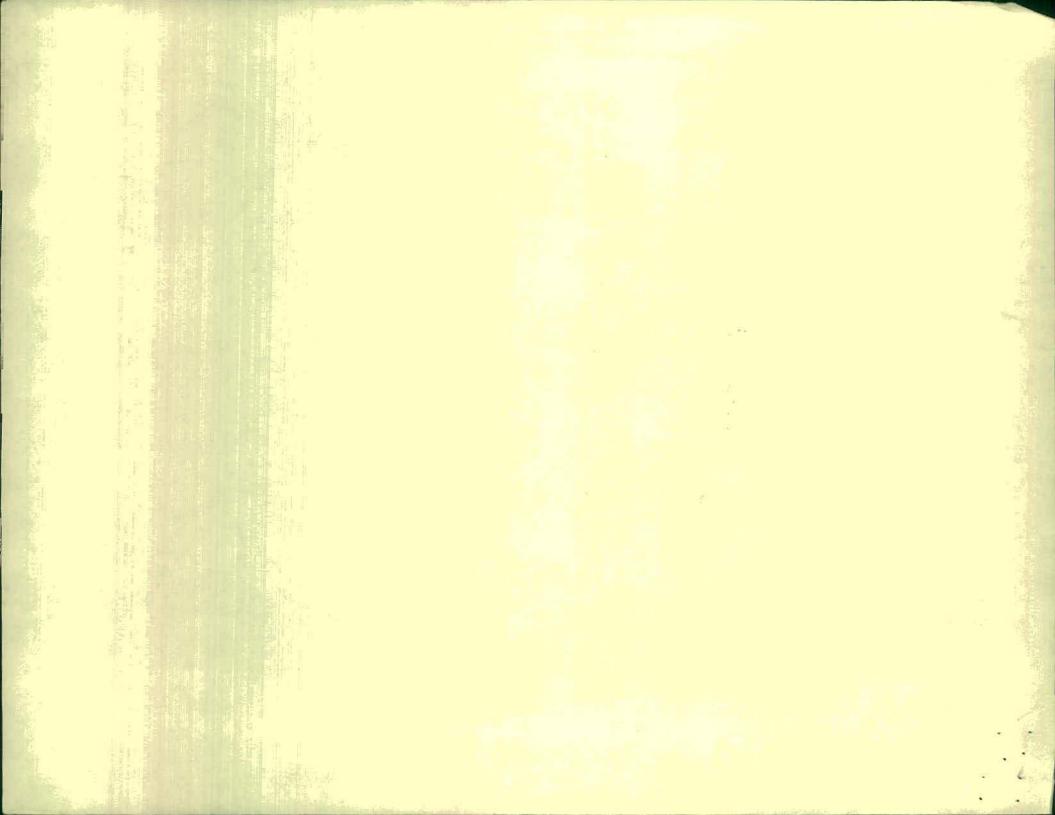




Page 2

Kim Johnston **Process Sheet** Drawing Name: ASPIRATOR Customer: CU-DAR001 Dart Helicopters Services Part Number: D2091 Job Number: 30137 Job Number: Description: Seq. #: Machine Or Operation: VISUAL WELDING INSPECTION QC9 5.0 MOB/08/15 Comment: VISUAL WELDING INSPECTION **OUTSIDE SERVICES OUTSIDE SERVICE** 6.0 1808/08/15 Comment: Sub-Contracting PURCHASING 39886956 Issue P/O: Black Anodize weldment from step 3 and Dwg D2095 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT ANODIZE A1449 Grommet 8.0 4.0000 Each(s)/Unit Total: 200:0000 Each(s) Comment: Qty.: Grommet Pick: Qty Part Number Description FF 08/09/23 A1449 Grommet A1622 9.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 200:0000 Each(s) Grommet Pick: Qty Part Number Description FF 08/09/23 A1622 Grommet LARGE FAB 1 10.0 Comment: LARGE FABRICATION RESOURCE 1 Install grommets as per Dwg D2091 INSPECT WORK TO CURRENT STEP QC5 11.0 P NECRI UR / ITS PREST FOR THOUSES DONOGE 1) me permane bluck anadize. Just in acid.

Form: rprocess



Monday, 1/8/2007 10:42:13 AM Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30137

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



13.0

QC21

FINAL INSPECTION/W/O RELEASE



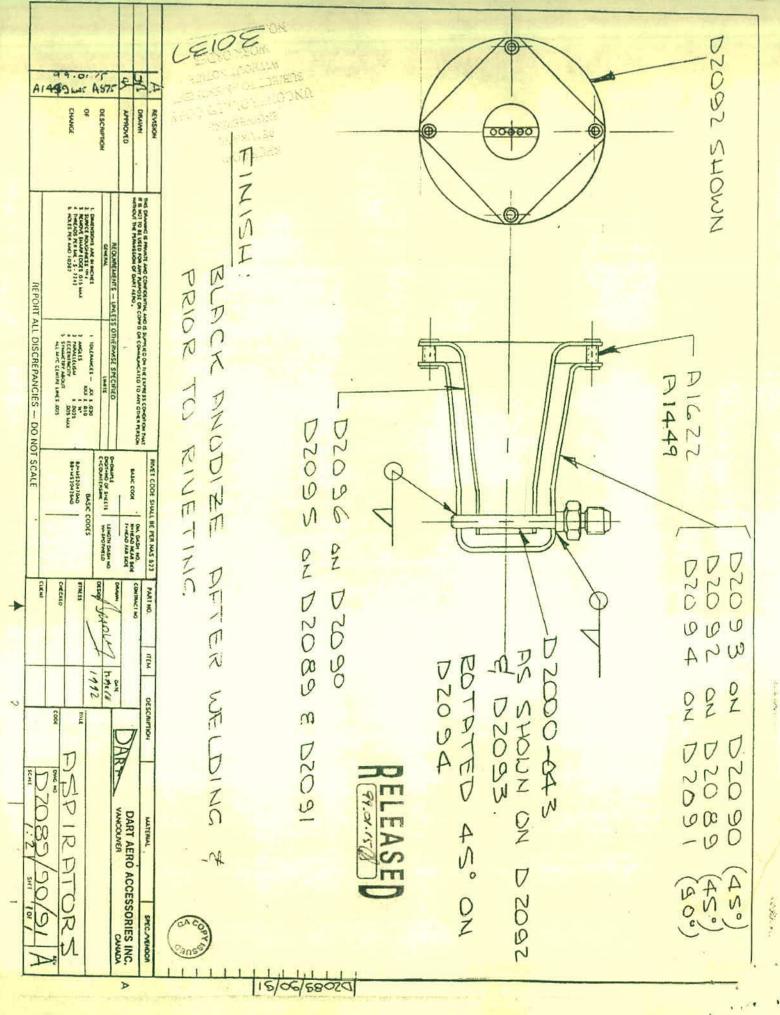
Comment: FINAL INSPECTION/W/O RELEASE

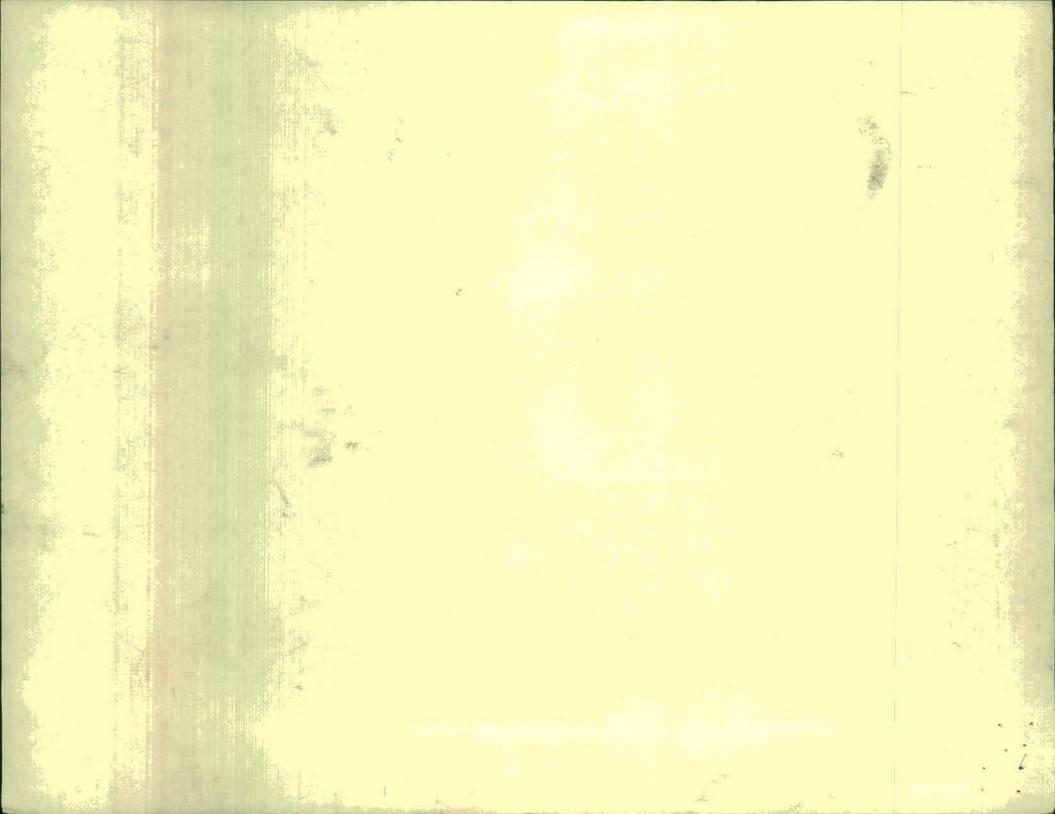
Job Completion



·MF- 68-04-23







ANODISATION et PEINTURE TNM INC.

C. OF C



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2 Telephone: (514) 429-7777 Fax: (514) 429-5108 Certifié ISO 9001-2000 certified approuvé NADCAP approved

63408

31-Mar-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY . ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: PURCHASE ORDER/

214586



Nadcap
Chemical Process
Nondestructive Testing

ITEM	COMMANDE ORDERED	SHIP	NAME OF TAXABLE PARTY OF THE PA	R & DESCRIPTION	PART PROCESS & TREATMENT
1	5	5	D2224 B 37744	7	
					RED ANODIZE PER MIL-A 8625F1 TYPE 1 CLASS 2
2	31	31	D2091 B 30137		*
					BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	100	100	D1038-58B B 38022	ā	(C)
					BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées. Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	M				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:	D2091	_ PAR #:	Fault Category:	NCR Yes No	DQA:	Date: 08/09/2
				0 79111		

QA: N/C Closed: D Date: 30/05/25

NCR: 3	0137-	- > Wo	ORK OR	DER NON-CONFORMANCE	(NCR)		16	
DATE OFFI		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
0604-03		Parts (D2094) sent for		See NCR 68.030 Finish D2094 bodie stock D2095 coves.	PD 5			
00-	V	not welcled, or inspected.	DS1412	. stock D2095 coves.	00/	66 66 29	Pasialz	forcations
							Ŧ	

NOTE: Date & initial all entries



ANUDISATION et PEINTURE TNM INC.

C. OF C



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2 Telephone: (514) 429-7777 Fax: (514) 429-5108 Certifié ISO 9001-2000 certified approuvé NADCAP approved

67430

25-Aug-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY . ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: PURCHASE ORDER/







ITEM	ORDERED ORDERED	EXPEDIE PART NUMBER & DESCRIPTION SHIPPED	PART PROCESS & TREATMENT
1	7	7 D2091 B30137	
2	8	8 D2000-047 B35293 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	10	10 D2224 B40891 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
			BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

Yous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées. Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

